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D3290-1
Job Sheet 209320



Part No: D3290-1

Job Qty: 6 pcs

DAS
21
9-89

Part Name: Frame



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/23/20

Job Tracking No:

Due Date: 5/18/20

Created By: Jennifer Renwick

Type: Stock

Description: SIOP

Note: DWG REV C IPP REV:A 12.06.13 NEW ISSUE DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		5/16/20	0.17	1.26	Waterjet - Flow		on 20/04/27
120	QC 8	6 pcs		5/16/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
							QC 8 - 66		
							QC 8 - 73		

DAS
40

APR 27 2020 9-89

130 Handfinish - 1-1 Chemical-B4B	6 pcs	5/16/20	0.00 0.75	Handfinish - 1 - 1 - B4B	BEB 20-04-29
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
135 QC 7	6 pcs	5/16/20	0.00 0.00	QC 7 - 10	20-04-29
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	

					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
					QC 7 - 83	
					QC 7 - 82	
					QC 7 - 87	
140	Powdercoat - 1 White GI(A)- B4B	6 pcs	5/18/20	0.00 0.29	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
150	QC 3	6 pcs	5/18/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
180	Packaging 3-1 - Stock - B4B	6 pcs	5/18/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	

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				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	6 pcs	5/18/20	0.00 0.00	QC 21 - SA - 21	DAS 21 3-25
				QC 21 - SA - 70	MAY 01 2020
				QC 21 - SA - 53	
Part Op 100 - 1-Cut as per DWG. DWG. Rev: <u>C</u> PROG. Rev: <u>C</u> 2-Debur if necessary Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Chemical Conversion Coat per QSI005 4.1) 135 - (QC7-Inspect Chemical Conversion Coat) 140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) 150 - (QC3- Inspect Part Finish) 180 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6S.063	6061-T6 .063 Sheet	22.5000 sf (3.75 ea)	100-Waterjet - Flow - 1	S2271116	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M6061T6S.063	23	377	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Window Frame	29.000inches $\pm$ 0.030	29.030 28.970	29.00	
2	Window Frame	14.000inches $\pm$ 0.030	14.030 13.970	14.00	
3	Window Frame	0.171inches + 0.005 - 0.001	0.176 0.170	170	
4	Window Frame	1.500inches $\pm$ 0.030	1.530 1.470	1.50	
5	Window Frame	1.110inches $\pm$ 0.030	1.140 1.080	1.11	
6	Window Frame	10.100inches $\pm$ 0.030	10.130 10.070	10.10	
7	Window Frame	18.500inches $\pm$ 0.030	18.530 18.470	18.50	
8	Window Frame	0.063inches $\pm$ 0.010	0.073 0.053	.062	
9	Window Frame	3.000inches $\pm$ 0.030	3.030 2.970	3.00	
10	Window Frame	4.500inches $\pm$ 0.030	4.530 4.470	4.50	
11	Window Frame	0.257inches + 0.006 - 0.001	0.263 0.256	.256	
12	Window Frame	13.610inches $\pm$ 0.030	13.640 13.580	13.61	

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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 90	CHECKED 15		MFG. APPR. E	APPROVED MD		DE APPR. 11	
DATE 09.09.18	DATE 09.09.18		DATE 09.09.18	DATE 09/09/21		DATE 09/09/21	

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK-0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
 (REF. DART SPEC. M6061T6S.040) REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET 0.040 THICK- 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
 (REF. DART SPEC. M5052H32S.040) REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 R 2009 -10- 09
 VNP

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality	DEPARTMENT/PROCESS	
Date : _____		Sequence #: _____	QTY Affected : _____
Description Work Order Deviation		Disposition	
		Completed By	
		Lead hand / Supervisor	
		QC / QA Coordinator	

Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details: _____	FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
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